Work Order Thursday, July 04				*103	1927*			ķ	FAR		Page 1
Revision ID:	03920-3 Seatbelt Guid	le Bracket		Accept	*N900	040	100) * §	Setup Sta	I	S1* S2*
Start Date: 7 Required Date: 7 Reference:	7/4/2013 7/18/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:				I	
Approvals:	Process Pla	an: MF	Date: \3-7-4	Tooling:	D	ate:	_	R	Run Sta	" 7	R1*
(QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr					·				
D3920	В										
100			- 4 - 4 - 4	0.00			······································	··-·			
100 Waterjet FLOW CNC Waterjet (こくしょしとう	,	FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if i	B	0.00	: 			_6	<u></u> <u></u>		JM3-07-UB
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
110 QC Quality Control	. &	Memo		0.00	· Management of the second			6_	6	·	Jm3-07-08
					· •						
120		QC8- Inspect parts - seco	and check	0.00	·						DÃS
120 QC Quality Control		Мето		0.00					130	1.05	<u>09</u>

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QA Closed:			Date:							W	ork Order up	date only	
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Part N	_					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descr	ription of work order update	1	nitial	Action		Sign &	:	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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		Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified ions Incomplete/Unclear ned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
(-	Wave/Tw	-			Fit/Function		1	Sequence		-	****	

Work Ord Thursday, July				*103	3927*	e.				•	Page 2
Item ID: Revision ID: Item Name:	D3920-3 Seatbelt Guid	le Bracket		Accept	*N900	040	100)* s	etup Star Stop	I VI	S1* S2*
Start Date: Required Date Reference:	7/4/2013 : 7/18/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item :					IV.	
Approvals:		an:	-			ate:		R	tun Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I 130 *120* Brake NC Brake NC	D	Operation Description Form as per dwg NC BRAKE Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp /2/07/23
*140 *140* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 0.00 21 3.7	23			6_			
150 *150* Packaging Packaging		Identify as per dwg & Sto	ock Location					-6x-			-SO 13-7-2

DQA:			Date:											•	
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				•		AEROSPACE
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	•				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is			noforming	Finishing			e/Packaging		Other
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	_	Crimp/Kink/Ripple/Wave				Burrs	 	1	ion Incomplete/U		_	Part Lost/Mi	-	<u> </u>	Weld
	<u> </u>	Crushing				Contamination	├	4	tions Incomplete/			Part Moved		<u> </u>	Wrong Stock Pulled
	-	Crushing Heat Treat				Countersink Cut Too Short	<u> </u>	Mislabe	gned/off center			Positioned V	_	_	lother
	_	Heat Treat Inspection Strip in Tube					\vdash	4				Power Loss/	ourge		Other
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Work Orde Thursday, July (*103	3927*							Page 3
Item ID: Revision ID: Item Name:	D3920-3 Seatbelt Guid	le Bracket		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
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Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:	- 		Run	Start Stop		R1* R2*
Sequence ID/ Work Center II ¹⁶⁰ *160*	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qty	-	Reject Number	Insp. Stamp
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Part N	lo.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.		Quality
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Root					Descr	ription of work order update	١	nitial	Ac	tion	T	Sign &	·		
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	Щ	Cuffs				Contamination		1	ions Incomplete/	<u>-</u>	_	Part Moved			Wrong Stock Pulled
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,		Wave/Tw	ist in Tub	oe		Fit/Function	L	Out of S	Sequence					1	

Picklist Print

Thursday, July 04, 2013 11:39:30 AM

Work Order ID:

103927

Parent Item:

D3920-3

Parent Item Name:

Seatbelt Guide Bracket

Start Date: 7/4/2013

Required Date: 7/18/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

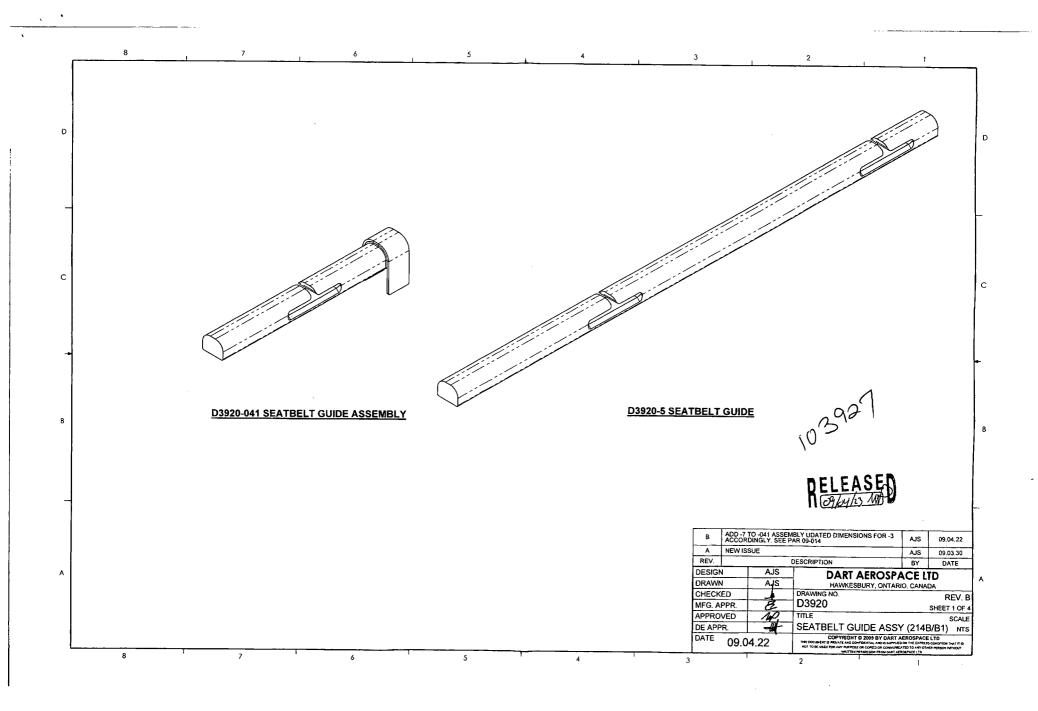
Comments:

IPP REV:A 13.07.04 AS PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	239.8300	0.032	0 .202105 .	3		Jm13-07-08

DQA:			Date:										•	DART.
			5 .			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
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		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Ŀ	Temperature/Cure
	Ц	Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	L	Weld
	Ш	Crimp/Kink/Ripple/Wave Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Ŀ	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	L	Positioned V	Vrong		-
	Ш	Heat Trea	it			Cut Too Short	L	Mislabe	eled	L	Power Loss/	Surge	L	Other
	Ш	Inspection	n Strip in	Tube		Drawing	L_	Misread	d d					
	-	Marks/Ch				Drill Holes		Off-set						
,	-	Turning S				Finish	<u></u>	4	Calibration			· · · · · · · · · · · · · · · · · · ·		
,		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence					

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DQA:			Date:											•	TO AC
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	\perp	wave/ IW	ist iii TUL	<i>/</i> C		T RY CURICUOIT	L	Jour or s	Sequence						

5 QTY -041 PART NUMBER DESCRIPTION No. D3920-041 SEATBELT GUIDE ASSEMBLY D3920-1 SEAT BELT GUIDE 10 D3920-3 SEAT BELT GUIDE BRACKET D3920-7 11 SEAT BELT GUIDE SHIM D D3920-1 SEAT BELT GUIDE D3920-3 SEATBELT GUIDE BRACKET (ASSEMBLE AT CHAMFERED END) - D3920-7 SEATBELT GUIDE SHIM (ASSEMBLE AT CHAMFERED END) 1.13 MIN **D3920-041 SEATBELT GUIDE ASSEMBLY** NOTES: D3920-041

1) MATERIAL:
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.58 lbs
8) WELDING: PER DART QSI 004 DESIGN AJS DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3920 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE

SEATBELT GUIDE ASSY (214B/B1) NTS

COPYRIGHT G 2001 BY OART AEROSPACELTO

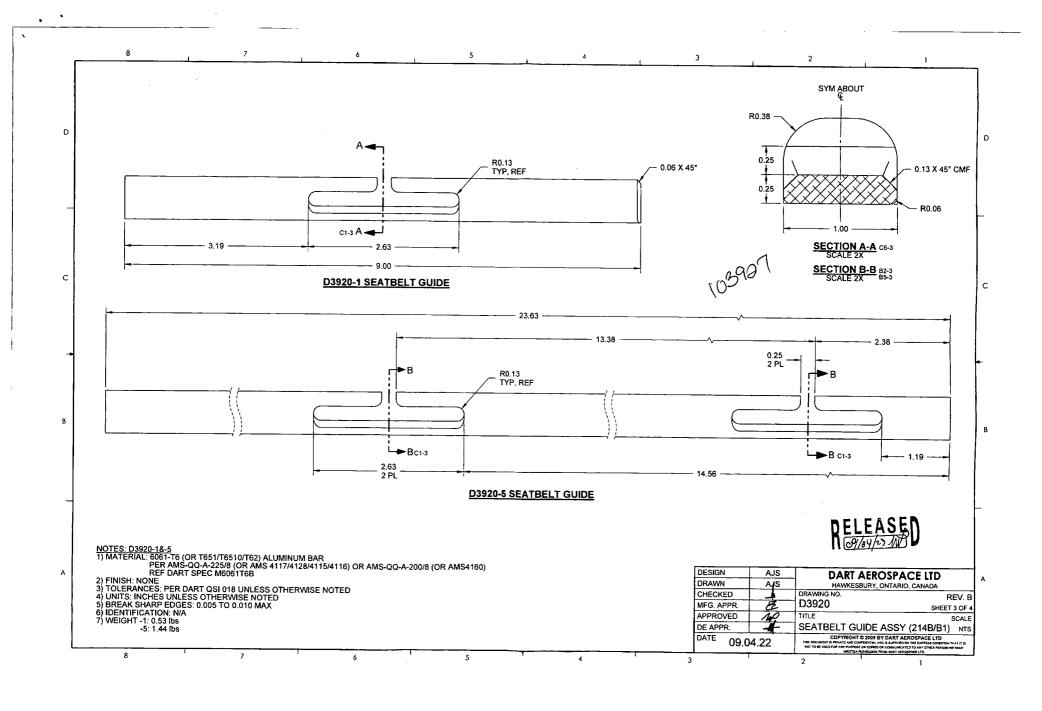
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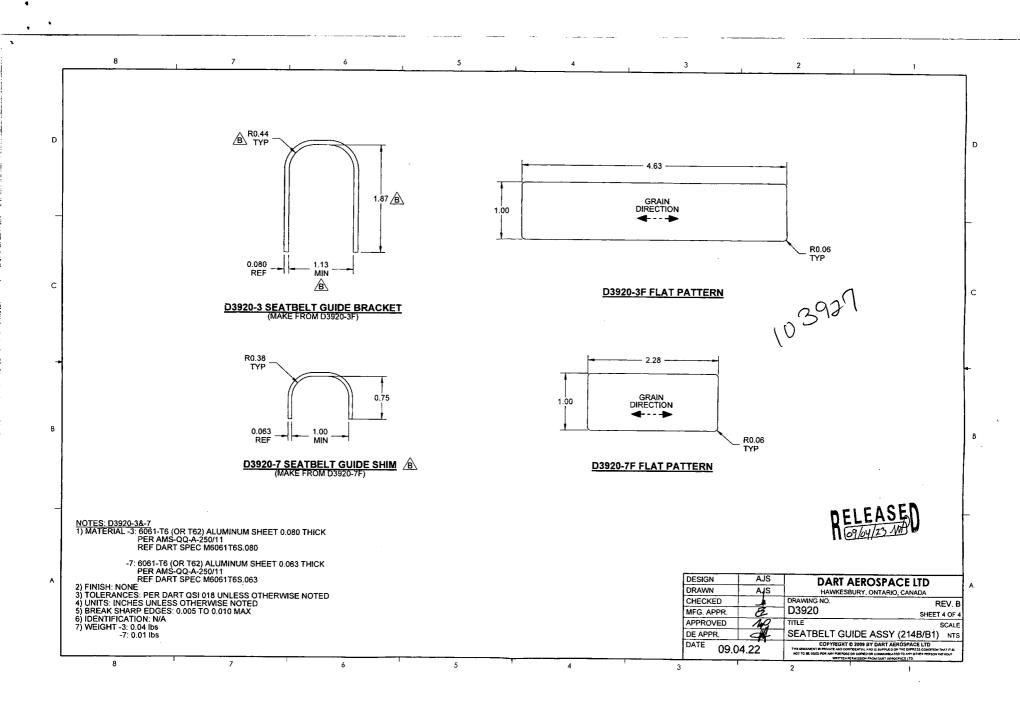
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		Cuffs				Contamination		1	ions Incomplete/	Unclear		Part Moved		Ļ	Wrong Stock Pulled
-	-	Crushing Heat Treat				Countersink	\vdash	1 -	ned/off center			Positioned V	_	-	1
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Work Orde	r:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
						Rework]		Skid-tube	Crosstube			Water Jet		Engineering
Part N	0.					Scrap	1 1		Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
						Use-as-is	1	Thern	noforming	Finishing		1	re/Packaging	-	Other
NCR N	0					Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Λ.	ction		Sign &			
Cause	1 .	Date	Step	Qty	Desci	or non-conformance	1	ief Eng	· ·	cription		Date	Verificatio	'n	QC Inspector
Design	<u> </u>		Осер	٦.,			 ``	ilet, Elig		cription		Date	Vermeatic		Qe mapeetor
Doc/Data	_													1	
Equip/Tooling															
Handling/Pre		-												1	
Material										·					
Operator														:	
Offset/Setup															
Process														1	
Supplier														į,	
Training					<u> </u>									:	
Transport														1	
Unapproved														1	
							FAI	ULT CAT	EGORY						
Landin	ig Gea	r				General		_				_		4	
1	Be	nding				Bend		Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
ļ	Ce	ntre No	t Concer	ntric	<u> </u>	BOM/Route		Grain				Over/Under			Set-up
		acks			<u> </u>	Broken/Damage/Defect		Hardwa	re		_	Part Incorre	ct		Temperature/Cure
1	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs		4 `	on Incomplete/	,		Part Lost/Mi	-	1	Weld
1	Cuffs					Contamination		1	ions Incomplete			Part Moved		L	Wrong Stock Pulled
	Crushing					Countersink	_	1 -	ned/off center	r		Positioned V	-	:	1
		at Trea				Cut Too Short	<u></u>	Mislabe			L	Power Loss/	Surge		Other
}	—	•	Strip in	Tube	-	Drawing	<u></u>	Misread						· ·	
ļ ļ.		arks/Ch			<u> </u>	Drill Holes	 	Off-set						1	
			equence			Finish		4	Calibration					_ !	
'	IW:	ave/Twi	ist in Tub	ne	- 1	Fit/Function	1	IOut of 9	Seguence						

fi:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	103927	
Description: Seather Guide Bracket	Part Number:	03920-3	
Inspection Dwg: 13920 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,00"	+1-0-030" +1-0-010"	1.002	_		ν	Jkm01
4,63"	1/-0.030	4,675	_		V	
4,63° 0.880°	11-000	1.002° 4,675° 0.078°)		ν	
·		<u> </u>	1			
A 20. 20. 20. 20. 20. 20. 20. 20. 20. 20.	1					
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		09/			
Measured by:	Im	Audited by:	Ø-89	Preliminary Approval:	
Date:	13-07-08	Date: (3-07-08	Date:	

ſ	Rev	Date	Change	Revised by	Approved
ſ	E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15